Work Orde						*762	271*				-				Page	1
Revision ID:	D3405-043 Lug Assembly				Acc	ept	*N9(าก	040	100) * :	Setup #		*N: *N:	S1* S2*	
	11/7/2011	Start Qty: Req'd Qty:		*1; *1;			Cust It		D:							
	Process Pla		K	Date://-//-(ooling: PC (Y/N):		-	ıte:]		Start Stop	*N *N	R1*	
Sequence ID/ Work Center ID		Operation Description				Set Up/ Run Hours	Tool	ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
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D3405	Rev	В														
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100 Waterjet		FLOW WATER	R JET emo			0.00					Bu	-11-0	(<u> </u>			_
FLOW CNC Waterjet	t	Dv Pro	Cut as per wg Rev: og Rev:_ Deburr if i	Dwg D3405										B) · ·	
110		QC2- Inspect p	arts off m	achine FAI/FAIB		0.00										
110 QC Quality Control		M	emo			0.00					Bu	- 11-9				-
Quanty Control																
120		QC8- Inspect p	arts - seco	ond check		0.00										
120 QC Quality Control		Мо	emo			0.00	lulio			(45	<u></u>				

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W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval ChiefÆng / Prod-Mgr	Approval OC Inspector
							Prod Mgr	
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
	O I E I	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 76221 *76221* Page 2 Monday, November 07, 2011 2:43:04 PM D3405-043 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop Item Name: Lug Assembly **Start Qty: 12.00** 11/7/2011 **Start Date: Cust Item ID: Required Date: 11/16/2011** Req'd Qty: 12.00 *12* **Customer:** Reference: Run Start **Tooling:** Date: Approvals: Process Plan: Date: SPC (Y/N): Date: Date: Plan Sequence ID/ Operation Set Up/ Tool ID Tool # Accept Reject Reject Insp. Number Stamp Code Qty Qty Work Center ID Description **Run Hours** 0.00 130 NC BRAKE *130* 0.00 Brake NC Memo 50 mail 22 Brake NC 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming QC5- Inspect part completeness to step on W/O 0.00 140 0.00 Memo Quality Control Weld per dwg A/R S.S. rod Batch: 118367 0.00 150 Large Fab *150*

Memo

0.00

15x Ø

Large Fab Large Fab

Weld as per Dwg D3405 use DT8484

Identify as D3405-043

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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	B	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	. 									
Part No		PAR #:								
NCR:		-	WORK ORDE	R NON-CONFORMA	ANCE (N	ICR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	Si	gn & ate	Verific Section		Approval Chief Eng	Approval QC Inspector

Work Ord				*762	721*							Page	e 3
Item ID: Revision ID: Item Name:	D3405-043 Lug Assembly	, .		Accept	*N900	<u>040</u>	100)* ፡	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	11/7/2011	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:					1.4		
Approvals:		in:				ate:		I		Start Stop	*N *N	R1* R2*	; ;
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC9- Inspect visual per 0	QSI004- Fusion Welds	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty	, .	Reject Number	Insp. Stamp	
170 *170* QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00				m	1)		12	.01	_(15
*180 *180 Powdercoat Powder Coating	a (White Gloss(Ref:4.3.5.1) Memo START TIM OVEN TEM FINISH TIM	E: PERATURE: 40	0.00 0.00 0.00				/5 x	(J)	/ -M	4	4/16	2/0 <i>6</i>

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W/O:			W	ORK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA: _	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C Cld	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	n Approval	Approval
DAIL	3121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Ord Monday, Novem		•		*762	721*						Page 4	4
Item ID: Revision ID: Item Name: Start Date:	D3405-043 Lug Assembly 11/7/2011	y Start Qty: 12.00	*12*	Accept	*N900 Cust Item I		100)*	Setup	Start Stop	*NS1* *NS2*	
Required Date		Req'd Qty: 12.00	*12*		Customer:	D.						
Reference:		- ; ·	17									
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:]	Run	Start	*NR1*	
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*NR2*	
Sequence ID/ Work Center I	ID	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	,]	Reject Insp. Number Stamp	erent en
190 QC Quality Control		Memo		0.00			-	_15_		<u> </u>	11-12-2	
200 *200* Packaging Packaging		Identify as per dwg & Sto Memo	ck Location:ST4	0.00				5	84	<u> </u>	-/2-02-	
210		QC21- Final Inspection -	Work Order Release	0.00				Ć &	1	(,,,	\p	
210 QC Quality Control		Memo		0.00						112		

(1/18/B)

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DATE	STEP	PRO	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	
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NCR:		\	WORK ORDE	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Secti Action Description Chief Eng	on B Sign & Date	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
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Picklist Print Monday, November 07, 2011 2:43:08 PM *76221* Work Order ID: 76221 D3405-043 *D3405-043* Parent Item: **Start Date:** 11/7/2011 Required Date: 11/16/2011 Parent Item Name: Lug Assembly **Start Qty: 12.00** Required Qty: 12.00 A05.09.01New issueKJ/JLM Comments: EC verified by: DD IPP B 09.01.28 Rev b dwg Qty per Kit Total Replacement Mfg/ Primary Last Route Unit of Qty on Qty Component Item ID/ Bin Item Location Location Seq ID Measure Hand Issued Item Name Qty Item ID Purch 67.0000 12 No 100 Each D3404-1 Manufactured ** GHW Lug Loc Otv Loc Code Location WA 7 7 70664 60 WA030

72326

74551

M304S11GA

Purchased

No

304/316 0.125 Sheet

M304S11GA

Location Loc Oty Loc Code MAT020 103.8 119006 50.5 119048 53.3

150

13

47

sf

103.8000

0.154

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Page 1

Status

Date

Issued

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W/O:			W	ORK ORDER CHANGE	S				,
DATE	STEP	PR	OCEDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
				,					
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	Res	olution:	Dispositi	on:	QA: N/C C	losed:		Date: _	
NCR:			WORK OR	ER NON-CONFORMAI	NCE (NC	R)			
	0750	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
	1 1								

DART AEROSPACE LTD	Work Order:	74221
Description: GHW Bracket	Part Number:	D3405-3
Inspection Dwg: D3405 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Articl	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Kejeci	Inspection	Comments
Ø0.438	+0.006/-0.001	بدولو (7		V BUZ	
1.50	+/-0.030	1,496	9		V	
1.750	+/-0.010	1752	2		V	
R0.63	+/-0.030	,63	>		R.G.	
3.00	+/-0.030	3,006	V		V	
8.00	+/-0.030	7.997	2		V	
6.751	+/-0.005	6,750	>		V	
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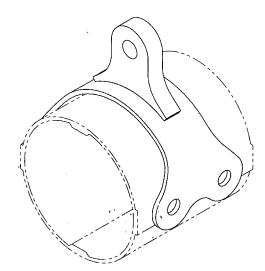
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-11-9	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue P/O D3405-043	KJ/JLM ,	/1//
В	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD +	Chall
-			——————————————————————————————————————	

Darl	Ae	ros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES		-		······································	
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No: PAR		PAR #:	PAR #: Pault Category: NCI			NCR: Yes No DQA: Date				
Resolution:				QA: N/C Closed:			Date:			
NCR:		\	WORK ORI	DER NON-CONFORMA	NCE (NCF	?)				
DATE	STEP	Description of NC		on B	Verific			Approval		
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector	
		·								

QTY. -043 ITEM QTY. PART NUMBER DESCRIPTION No. LUG ASSEMBLY D3405-041 Х 1 D3405-043 LUG ASSEMBLY 2 Х D3404-1 11 GHW LUG D3405-1 GHW BRACKET 12 GHW BRACKET D3405-3 13



D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY

B

SUBJECT TO AMENDMENT

D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "5" SIZE BORDER FLAT PATTERNS FOR -1 & 3 JINCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198) SHEETS 3 & 4 ZONE A6 4 .120 DIM WAS 4.100. 08.09.19 05.03.08 Α REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3405 MFG. APPR SHEET 1 OF 4 TITLE APPROVED SCALE **GHW LUG ASSEMBLY** NTS DE APPR COPYRIGHT © 2005 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND COMPOSITION FOR SUPPLIED ON THE DOPESS COMMON THAT THE
NOT TO BE USED FOR HAY REPOSE OF COMPOSITION COMMUNICATED TO ANY OTHER PRISOSHWITHOUT
WHETERS PERMISSION FROM ONAL PRISOSHWITHOUT DATE 08.09.19

NOTES: 1) MATERIAL: N/A

2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: -041, 0.85 lbs -043, 0.87 lbs

5

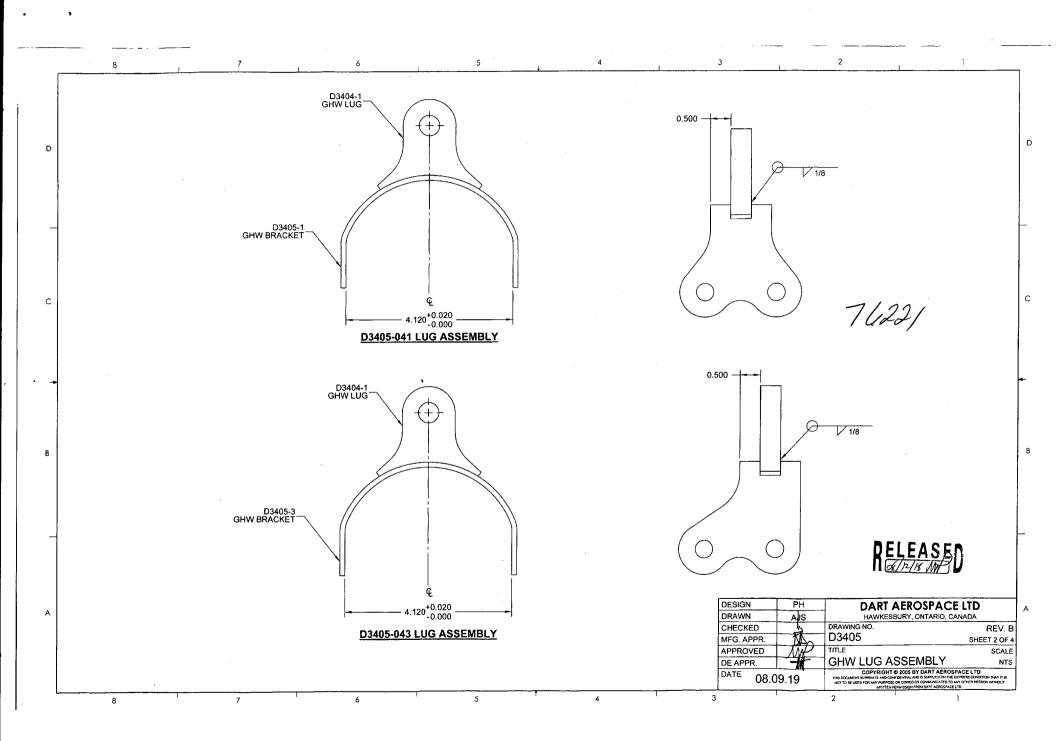
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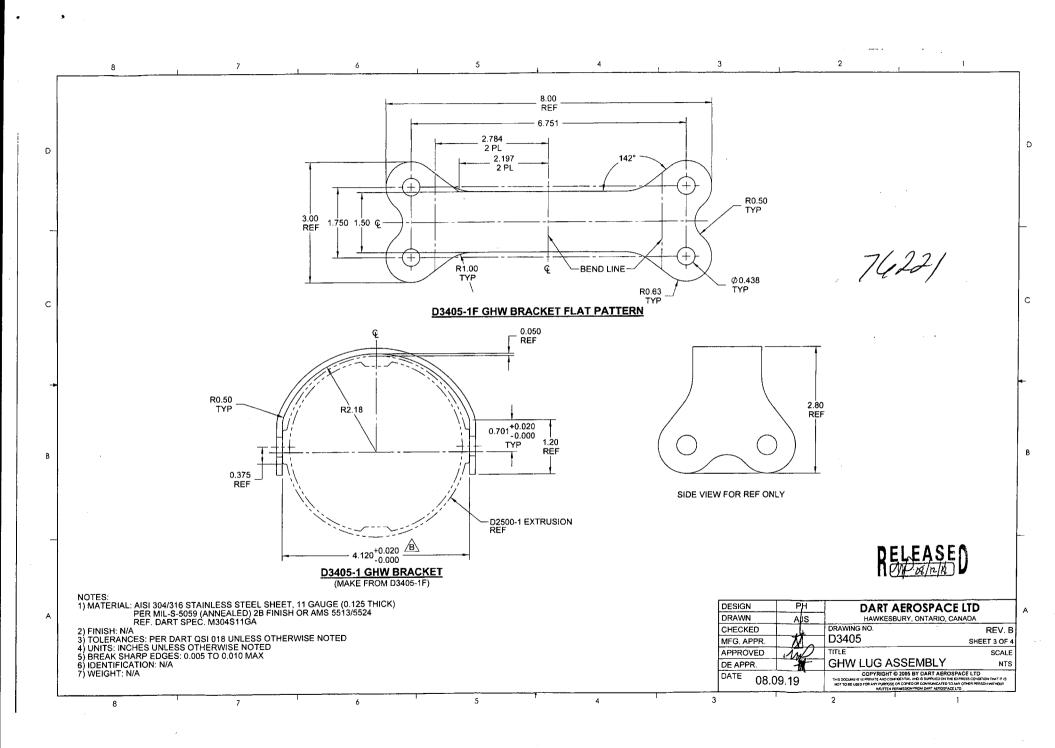
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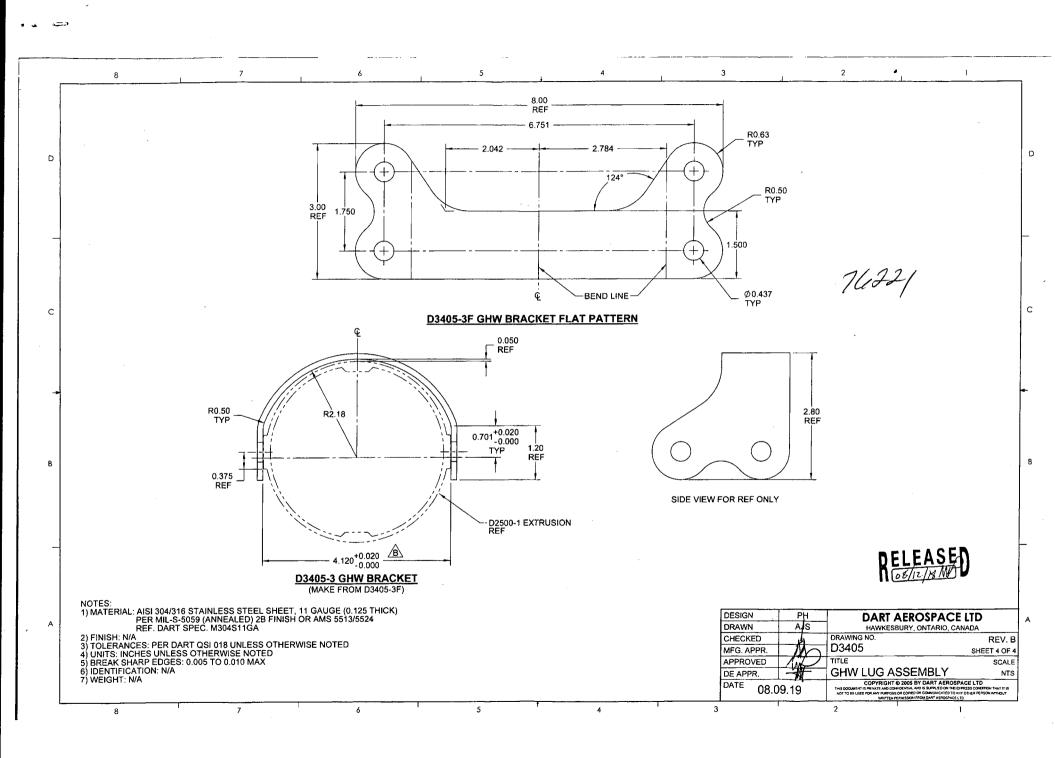
W/O:			W	ORK ORDER CHAN	GES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes 1	No DQA:	Date: _		
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DATE	STEP	Description of NC	In it is a		ction B Sign &	Verification		Approval	
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W/O:			W	ORK ORDER CHANG	ES			 		
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR	: Yes N	lo DQ	A:	Date:	
			Disposition: QA: N							
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DATE	STEP	Description of NC	Corrective Action Section			Sign &	Verific		Approval	Approval
	-	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector



W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr App QC Inst	• ,	
	Proval Ispector	
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:		
Resolution: Disposition: QA: N/C Closed: Date:		
NCR: WORK ORDER NON-CONFORMANCE (NCR)		
DATE STEP Description of NC Corrective Action Section B Verification Approval App	roval	
Section A Section A Section A Chief Eng Chief	nspector	



Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval Chief Eng / Approval DATE STEP PROCEDURE CHANGE Ву Date Qty QC Inspector Prod Mgr

Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____

Resolution:		esolution:	Disposition: QA: N/C Closed:				Date:		
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries